

Date: Thursday, 5/4/2006 11:14:33 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : EYEBALL ADAPTER
Job Number : 26960	
Estimate Number : 12244	
P.O. Number : N/A	Part Number : D3480043
This Issue : 5/4/2006 S.O. No. : N/A	Drawing Number : D3480 REV.A
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : SMALL /MED FAB	Drawing Revision : A
Previous Run : 26698	Material : N/A
Written By : <i>HS</i>	Due Date : 5/28/2006
Checked & Approved By : <i>06.05.05</i>	Qty: <i>4</i> Um: Each
Comment : est rev. A 06.02.07 new issue EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D34801	Flange
-----	--------	--------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty	Part number	Description	Batch
1	D3480-1	Flange	B26134

2.0	NAS1031C3W	Nutplate
-----	------------	----------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 32.0000 Each(s)

Pick:

Qty	Part number	Description	Batch
4	NAS1031C3W	Nutplate	M100049

SB 06/05/17 (4)

3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



Comment: SMALL & MEDIUM FAB RESOURCE 1

Spot weld as per dwg D3480

SB 06/05/17 (4)

4.0	QC5/9	WELD INSPECTION
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Comment: WELD INSPECTION

206-05-18 (4)

5.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Identify with a permanent fine point marker and Stock

Location: *2442*

206/05/18 (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: DP Date: 06/05/19
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 5/4/2006 11:14:33 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: EYEBALL ADAPTER

Job Number: 26960

Part Number: D3480043

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL
Inspection Level 21

Handwritten: 06/05/19 (4)

Job Completion



Handwritten: 06.05.19

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

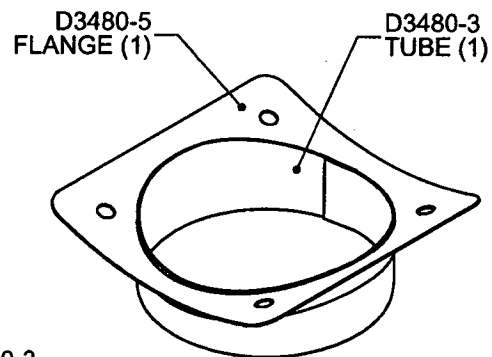
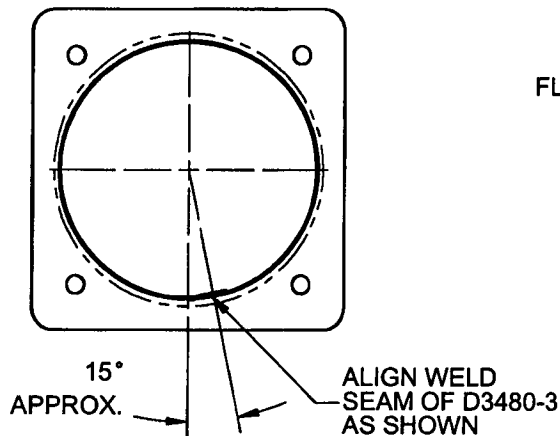
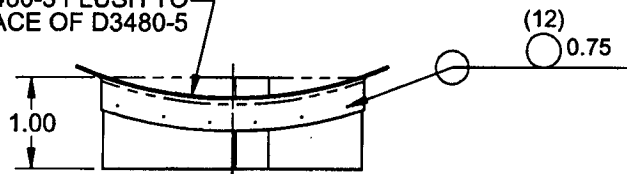
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3480	REV. A SHEET 1 OF 6
DATE 06.02.06		TITLE EYEBALL ADAPTER	SCALE 1:2
A	06.02.06	NEW ISSUE	

[Signature] 06.04.03SPOT WELD PARTS, THEN
CUT D3480-3 FLUSH TO
SURFACE OF D3480-5**D3480-041 EYEBALL INLET ADAPTER**SHOP COPY
RETURN TO
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *26959***NOTES:**

- 1) SPOT WELD PER DART QSI 004
- 2) FINISH: NONE
- 3) IDENTIFY WITH DART P/N D3480-041 USING FINE POINT PERMANENT INK MARKER
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

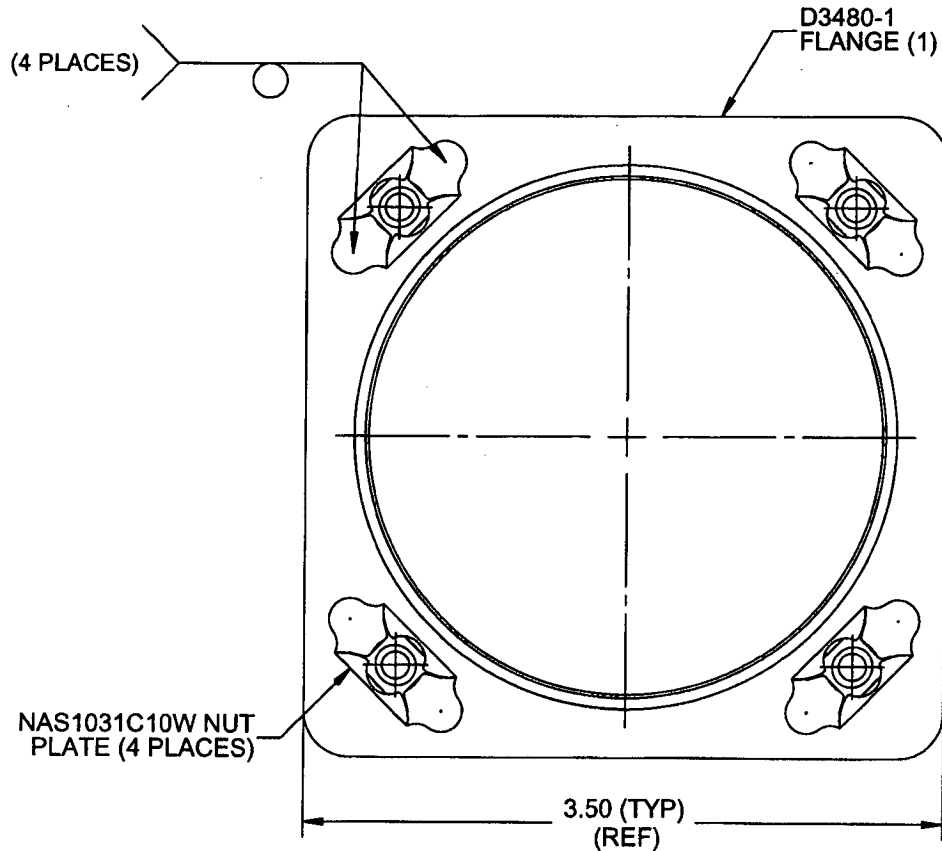
QTY -041	P/N	DESCRIPTION
X	D3480-041	EYEBALL INLET ADAPTER
1	D3480-3	TUBE
1	D3480-5	FLANGE

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DESIGN B	DRAWN BY B	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3480	REV. A SHEET 2 OF 6
DATE 06.02.06		TITLE EYEBALL ADAPTER	SCALE 1:1

**D3480-043 EYEBALL ADAPTER****NOTES:**

- 1) SPOT WELD PER DART QSI 004
- 2) FINISH: NONE
- 3) IDENTIFY WITH DART P/N D3480-043 USING FINE POINT PERMANENT INK MARKER
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

QTY -041	P/N	DESCRIPTION
X	D3480-043	EYEBALL ADAPTER
1	D3480-1	FLANGE
4	NAS1031C3W	NUTPLATE

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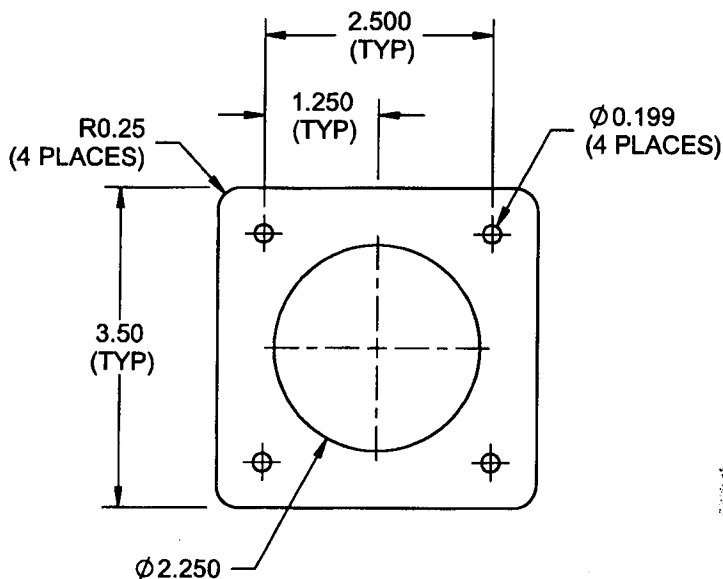
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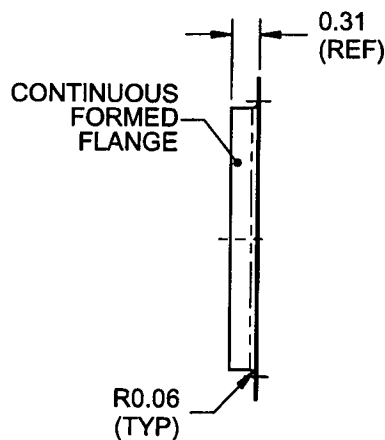
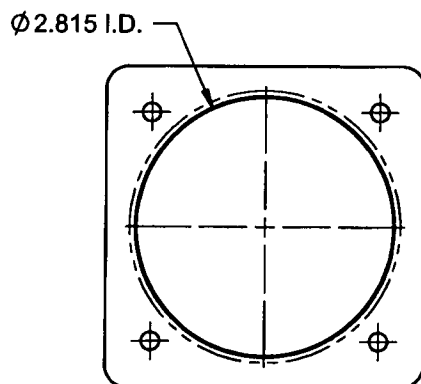


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DATE 06.02.06		TITLE EYEBALL ADAPTER	SCALE 1:2



[Handwritten: 06-04-03]

D3480-1F FLAT PATTERN



D3480-1 FLANGE (MAKE FROM D3480-1F)

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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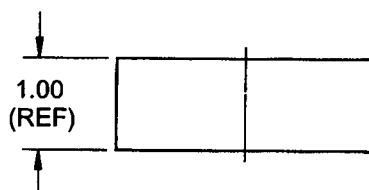
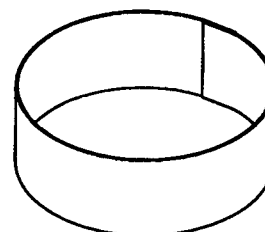
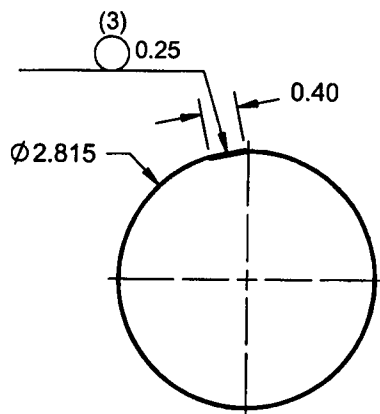
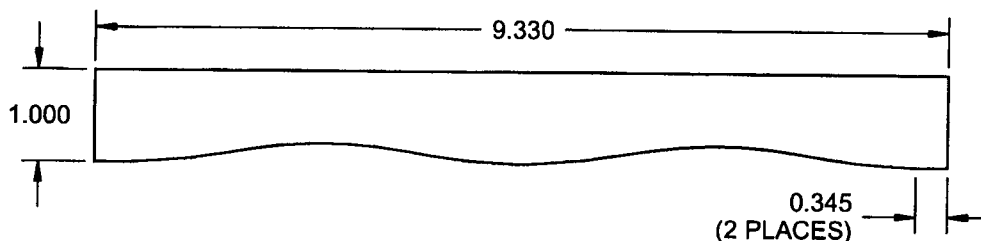
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DATE 06.02.06		TITLE EYEBALL ADAPTER	SCALE 1:2

**D3480-3 TUBE****D3480-3F TUBE FLAT PATTERN****NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH
26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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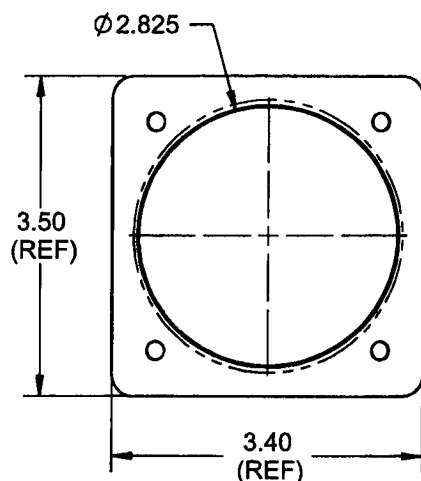
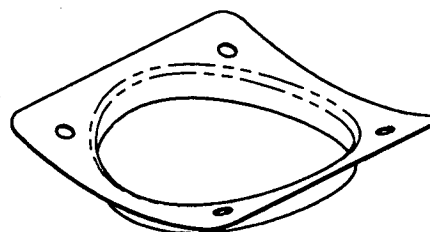
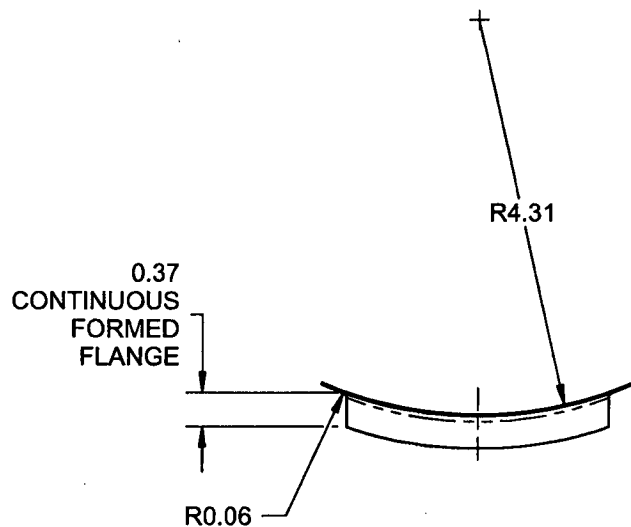
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DATE 06.02.06		TITLE EYEBALL ADAPTER	SCALE 1:2



[Handwritten signature] 06.04.03

D3480-5 EYEBALL ADAPTER FLANGE

NOTES:

- 1) MATERIAL: MAKE FROM D3480-1F
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

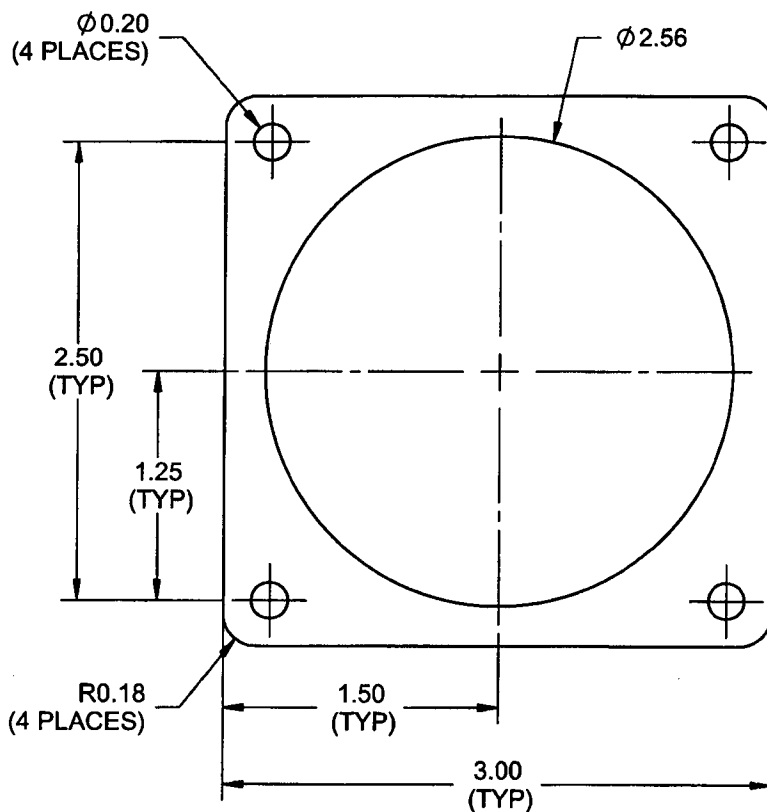
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DATE 06.02.06		TITLE EYEBALL ADAPTER	SCALE 1:1



[Handwritten signature] 06.04.03

D3480-7 GASKET

NOTES:

- 1) MATERIAL: RED (OR GRAY) 60 DUROMETER HI-TEMPERATURE SILICONE SHEET, 0.125" THICK (REF. DART SPEC. M-SIL60-.125) UNCONTROLLED COPY
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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